



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3535-25
Job Sheet 179058



DAS
21
9-59

Part No: D3535-25

Job Qty: 20 ea

Part Name: Wearplate Center



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/13/18

Job Tracking No:

Due Date: 7/2/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: URF 16-638 DWG REV B U/R IPP Rev:A New Issue 07-02-15 JLM IPP Rev:B As per Rev B 07-08-31 JLM
Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	7/2/18	7/2/18	0.00	0.00	Start Up Waterjet		DE 18/06/18
100	Waterjet	20 pcs	7/2/18	7/2/18	0.00	1.34	Waterjet1		DE 18/06/18
110	QC	20 pcs	7/2/18	7/2/18	0.00	0.00	QC2 Waterjet-2		DE 18/06/18
120	QC	20 pcs	7/2/18	7/2/18	0.00	0.00	QC8-2		38
130	Brake NC	20 pcs	7/2/18	7/2/18	0.12	0.83	Brake NC 1		DAS 38
140	QC	20 pcs	7/2/18	7/2/18	0.00	0.00	QC5		38
150	Powdercoat	20 pcs	7/2/18	7/2/18	0.00	0.33	Powdercoat3		DE 18-06-04
160	QC	20 pcs	7/2/18	7/2/18	0.00	0.00	QC3		38
170	Packaging	20 pcs	7/2/18	7/2/18	0.00	0.00	Packaging3-1	FP002	BE 18-07-03
180	QC21-SA	20 Ea	7/2/18	7/2/18	0.00	0.00	QC21		DAS 21 9-59

M136370

START: 10:10 O.V.T: 320 FINISH: 10:40

JUL 04 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S20GA	304/316 .040 Sheet	11 sf (.55 ea)	90-Start up Operation	5055007

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S20GA	11	111	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearshoe	1.885inches ± 0.010	1.895 1.875		
2	Wearshoe	1.937inches ± 0.010	1.947 1.927		
3	Wearshoe	1.450inches ± 0.010	1.460 1.440		
4	Wearshoe	5.450inches ± 0.010	5.460 5.440		
5	Wearshoe	10.900inches ± 0.010	10.910 10.890		
6	Wearshoe	16.350inches ± 0.010	16.360		

DQA: _____ Date: _____
QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only



Work Order:		DISPOSITION		AGAINST DEPARTMENT/PROCESS				Work Order update only																																					
Part No.:		Rework		Skid-tube		Cross tube		Water Jet																																					
NCR No.:		Scrap		Machining		Small Fab		Prod. Eng. Coord.																																					
Date:		Use-as-is		Thermoforming		Finishing		Rec/Store/Packaging																																					
Step #:		Suspected Unapproved		Large Fab		Composite		Supplier																																					
Description Work Order Deviation		Disposition		QTY Effective:		MRB (QS1042) Approval																																							
 Container No: S082036 Part: D3535-25 Job No: 179058 Serial No/Batch: S082036 Revision: B Inspector: Exp Date: Instructions: URF16-638																																													
 DART Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 813 832-6200 Email: sales@dartaero.com www.dartaerospace.com																																													
Root Cause <table border="1"><tr><td>Environment</td><td>No Re-verificat</td><td>Positioned Wrong</td></tr><tr><td>Design</td><td>Operator</td><td>Outside Dimensions</td></tr><tr><td>Doc/Data</td><td>Offset/Setup</td><td>Over/Under tolerance</td></tr><tr><td>Equip/Tooling</td><td>Supplier</td><td>Part Incorrect</td></tr><tr><td>Handling/Pre</td><td>Training</td><td>Part Lost/Missing</td></tr><tr><td>Material</td><td>Use for Testi</td><td>Part Moved</td></tr><tr><td>Internal Transport</td><td>Poor Information</td><td>Drawing</td></tr><tr><td>Tribal Knowledge</td><td>Rushing</td><td>Finish</td></tr><tr><td>LOA</td><td>Product Improvement</td><td>Misread</td></tr><tr><td>Substation</td><td>Process Improvement</td><td>Turning Sequence</td></tr><tr><td>Past Expiry Date</td><td>Manufacturing Process</td><td></td></tr><tr><td>Misidentified</td><td>Past Due</td><td></td></tr></table>										Environment	No Re-verificat	Positioned Wrong	Design	Operator	Outside Dimensions	Doc/Data	Offset/Setup	Over/Under tolerance	Equip/Tooling	Supplier	Part Incorrect	Handling/Pre	Training	Part Lost/Missing	Material	Use for Testi	Part Moved	Internal Transport	Poor Information	Drawing	Tribal Knowledge	Rushing	Finish	LOA	Product Improvement	Misread	Substation	Process Improvement	Turning Sequence	Past Expiry Date	Manufacturing Process		Misidentified	Past Due	
Environment	No Re-verificat	Positioned Wrong																																											
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Material	Use for Testi	Part Moved																																											
Internal Transport	Poor Information	Drawing																																											
Tribal Knowledge	Rushing	Finish																																											
LOA	Product Improvement	Misread																																											
Substation	Process Improvement	Turning Sequence																																											
Past Expiry Date	Manufacturing Process																																												
Misidentified	Past Due																																												

			16.340
7	Wearshoe	21.800inches $\pm$ 0.010	21.810 21.790
8	Wearshoe	0.188inches $\begin{matrix} + 0.005 \\ - 0.001 \end{matrix}$	0.193 0.187
9	Wearshoe	12.750inches $\pm$ 0.010	12.760 12.740
10	Wearshoe	6.750inches $\pm$ 0.030	6.780 6.720
11	Wearshoe	6.000inches $\pm$ 0.030	6.030 5.970
12	Wearshoe	0.300inches $\pm$ 0.010	0.310 0.290
13	Wearshoe	0.300inches $\pm$ 0.010	0.310 0.290
14	Wearshoe	0.038inches $\pm$ 0.010	0.048 0.028

Plex 6/13/18 8:30 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : _____									